

34

Date: Tuesday, 7/17/2007 2:01:25 PM  
User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : N1 GEARBOX ACCESS PANEL KIT  
Job Number : 33598  
Estimate Number : 12505  
P.O. Number :  
This Issue : 7/17/2007 S.O. No. :  
Prsht Rev. : NC Part Number : D412705017  
First Issue : 1 / Type : SMALL / MED FAB Drawing Number : D3255 REV B  
Previous Run : 28819 Material :  
Due Date : 8/24/2007 Qty: 2 Um: Each  
Written By :  
Checked & Approved By : 07.07.17  
Comment : Est Rev: C Removed Manufacturing 06-08-02 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: Photocopy bluefile & type labels per PPPD412-705-017 CHG001

08/1/22

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Pick Packing Kit

3.0 D3255041 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Access Panel Assembly

Batch: 33603

PC 8/1/25 (2)

4.0 D3255042 Access Panel Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Access Panel Assembly

533604 50 8/1/28 (2)

5.0 AN3C3A Bolt



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)

Bolt

Batch: M106277

PC

6.0 MS932109 Washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)

Washer

M106277 57X

PC 8/2/16 (2)

M106883 3X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: DD Date: 28/01/31  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: N1 GEARBOX ACCESS PANEL KIT

Job Number: 33598

Part Number: D412705017

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

MS20427M33

Rivet



Comment: Qty.: 48.0000 Each(s)/Unit Total : 96.0000 Each(s)

Rivet

Batch: M106303

8.0

MS21060L3K

Nut Plate



Comment: Qty.: 24.0000 Each(s)/Unit Total : 48.0000 Each(s)

Nut Plate

Batch: M126280

9.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-705-017

Location: A

PPP Rev: A

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

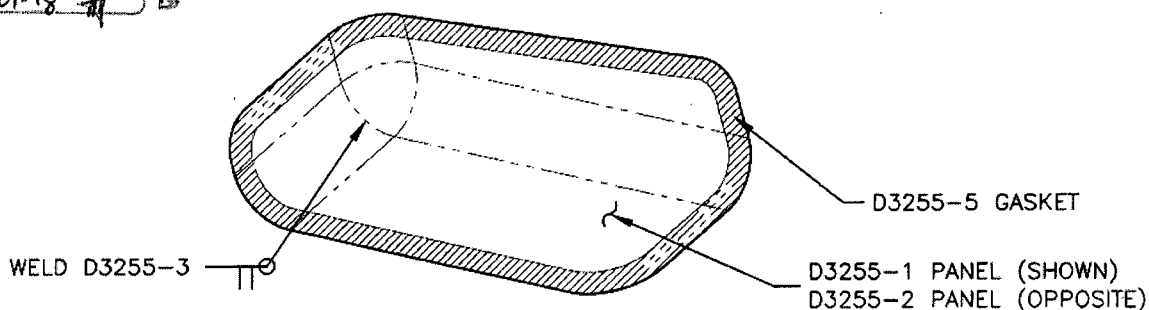
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

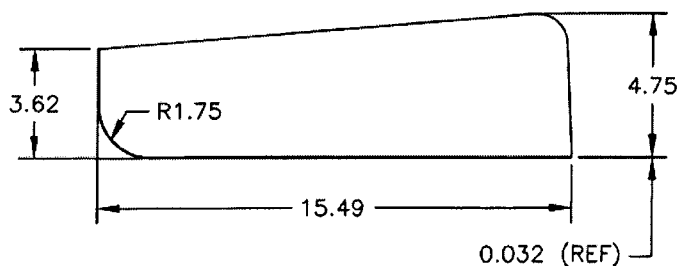
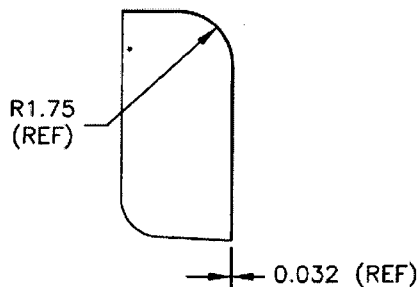
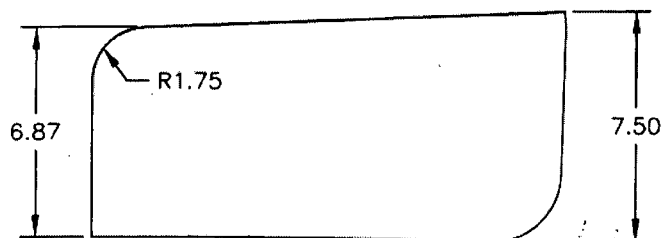


DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05-01-18 #



**D3255-041 ACCESS PANEL (SHOWN)**  
**D3255-042 ACCESS PANEL (OPPOSITE)**



**D3255-1 BEND DETAIL**  
**D3255-2 OPPOSITE**

**D3255-041/-042 NOTES:**

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

SHOP COPY  
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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 33598

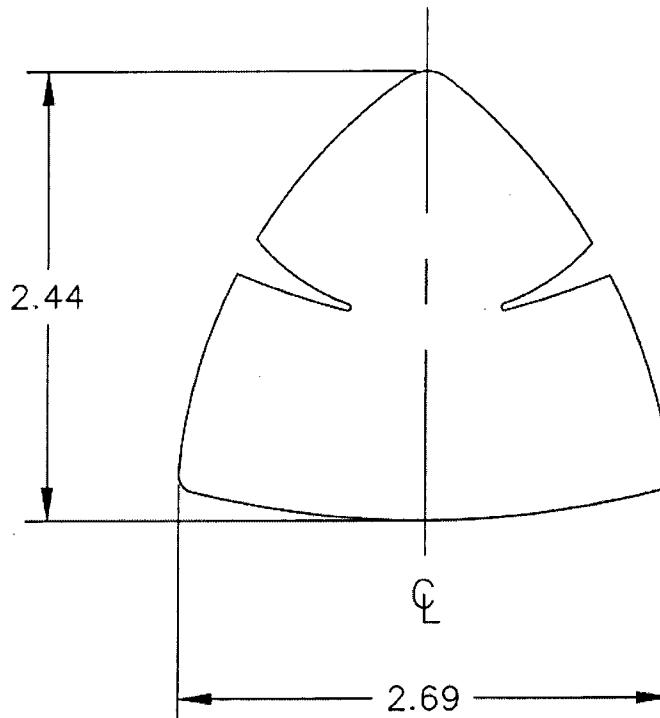
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DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED  
05-01-18 JF



**D3255-3 CAP**  
**FORM TO FIT D3155-1/-2**

**D3255-3 NOTES:**

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

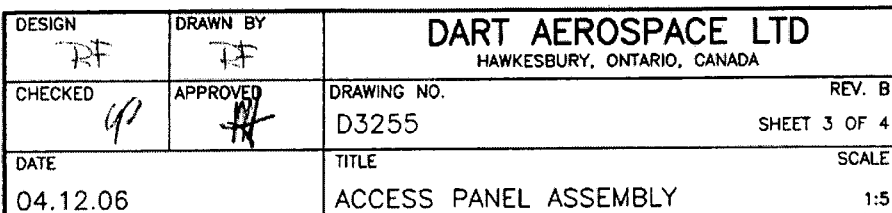
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WITHOUT NOTICE

WORK ORDER

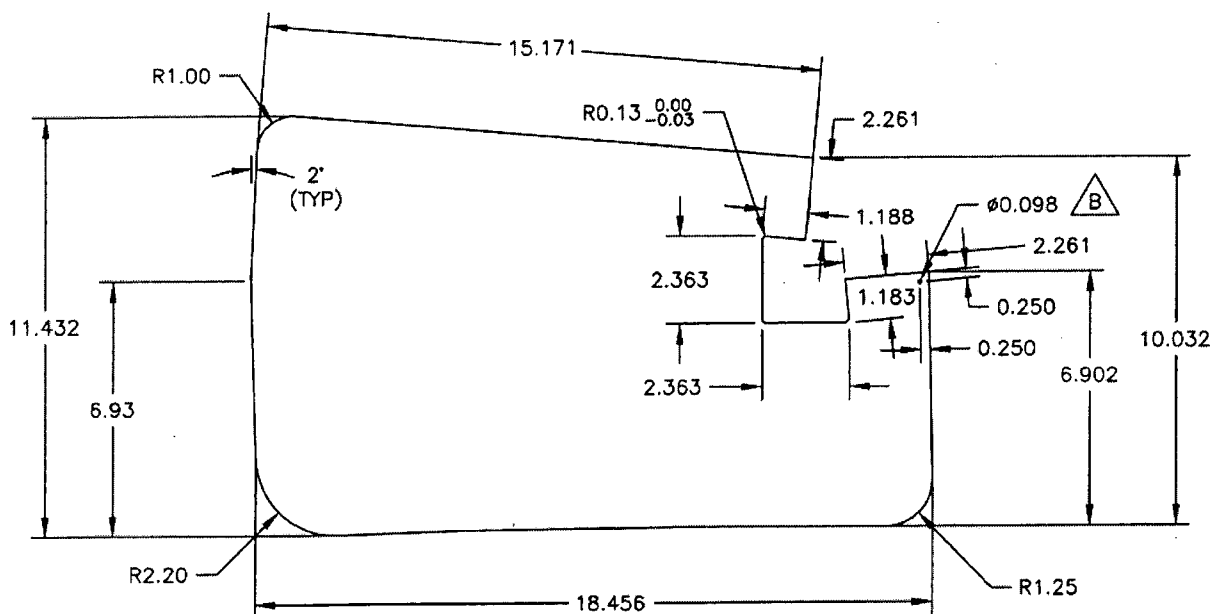
33598

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RELEASED  
05-01-18



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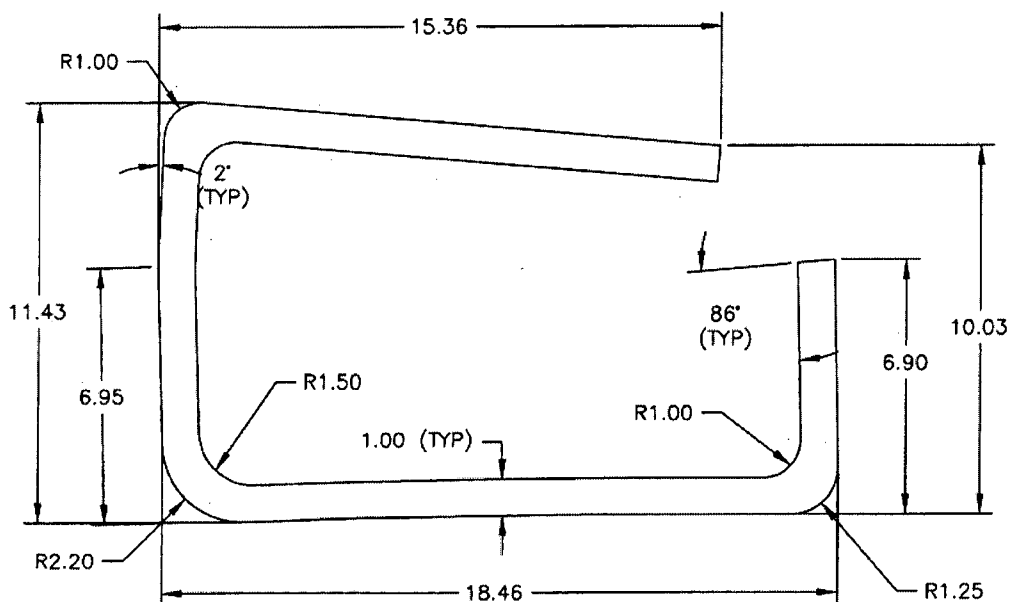
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DESIGN #	DRAWN BY #	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 41	APPROVED #	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED  
05-01-18 #



### D3255-5 GASKET

#### D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F  
P/N SIL/F 36x36x1/16  
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Checked & Approved By : *[Signature]* 07.07.17  
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*07.07.31*

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Batch: \_\_\_\_\_

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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)  
Access Panel Assembly

*REFERENCE ONLY*

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Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)  
Bolt  
Batch: \_\_\_\_\_

6.0 MS932109 Washer



Comment: Qty.: 30.0000 Each(s)/Unit Total : 60.0000 Each(s)  
Washer